

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003143**Date Inspected:** 30-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG side, bottom and deck panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA performed 10% Ultrasonic Testing (UT) verification on the following OBG segment 3BW weld joints: BP-007A to BP-008A and BP-009A to BP-008A. All welds examined appeared to be compliant with AWS D1.5 2002 and the contract documents.

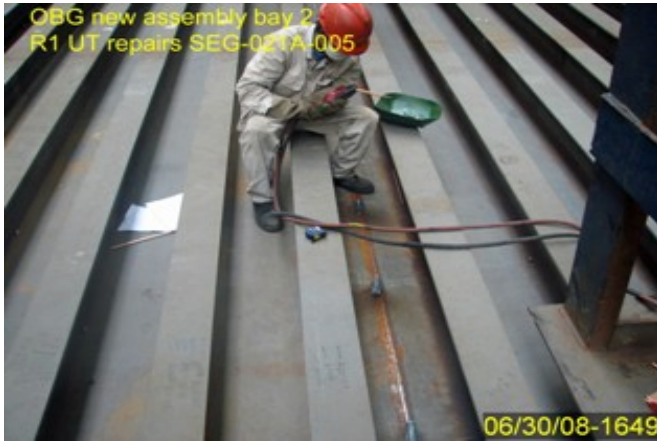
QA could not locate the following floor beam sections for 10% UT verification: SSD19-PP-029-136 and 137, SSD19A-PP029-132 and 133, SSD20-PP031-136 and 137 and SSD20A-PP031-132 and 133. According to ZPMC "notification of witness inspection" document no.: 00612, these welds were UT'ed by ZPMC on this date at 14:55 hrs.

QA observed ZPMC qualified welding personnel excavating four R1 UT repairs on bottom panel joint SEG-021A-005 BP-029 to BP-083 and one R1 UT repair on bottom panel joint SEG-021A-006 BP-029 to BP-137 following the guide lines of approved standard weld repair procedure defined in ZPMC WQCP section 9 and recorded on weld repair report# B-WR477 and B-WR478.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Other general observations include ZPMC personnel fitting and welding OBG temporary support columns, grinding and weld bevel prep on various OBG components.



Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
